

Work Order ID 76485

Tuesday, November 15, 2011 2:41:25 PM

76485

DDD

Page 1

Item ID: D3372-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Cam Lock Shaft

Stop ***NS2***

Start Date: 11/15/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 11/22/2011 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 11-11-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3372	Rev B								

100

0.00

100

Hardinge CNC LATHE SMALL

Doosan

Memo

0.00

Doosan Lathe

Machine D3372-5 as per Folio FA497 and Dwg D3372
Identify as D3372- ←

Deburr

WWSIG

8 0

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

WWSIG

8 0

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

B.A 11/11/16

8 0

Work Order ID 76485

76485

Page 2

Tuesday, November 15, 2011 2:41:25 PM

Item ID: D3372-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cam Lock Shaft
 Start Date: 11/15/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 11/22/2011 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: ST 48 Memo	0.00 0.00							
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

8x 11-11-18.

11/11/21

11-11-18
(8)

Picklist Print

Tuesday, November 15, 2011 2:41:24 PM

Page 1

Work Order ID: 76485
Parent Item: D3372-5
Parent Item Name: Cam Lock Shaft

Start Date: 11/15/2011 Required Date: 11/22/2011
Start Qty: 8.00 Required Qty: 8.00

Comments: IPP A05.01.18New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.375 303 Round Bar 0.375"		Purchased	No			100	f	25.8010	0.075	0.6315789			
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						MAT028		25.801					
						115806		1.711					
						115868		24.09					

SA 10/11/16
- 65 ft

DART AEROSPACE LTD		Work Order: 76485
Description: Cam Lock Shaft		Part Number: D3372-5
Inspection Dwg: D3372	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.390	+0.010/-0.000					
0.200	+0.010/-0.000	205	/			
R0.188	+/-0.010	R.188	/			
0.290	+0.010/-0.000					
0.563	+/-0.010					
0.170	+/-0.010					
Ø0.365	+/-0.010					
1/4-20 Major dia	0.241 - 0.248					
MOW	0.252 - 0.259					
R.188	±.010	R.188	/			
.200	±.010	.205	/			
.450	±.010	.445	/			
.433	±.010	.433	/			
Ø.365	±.010	Ø.375	/			
.90	±.030	.701	/			
.175	±.010	.175	/			
R.015x035	±.010	R.015x035	/			
10-32UNF2A	N/A		/			
Major Ø	.1831/.1891	.187	/			
M.O.W.	.228/.234	.230	/			

Measured by: SA
Date: 10/11/16

Audited by: B.n
Date: 11/11/16

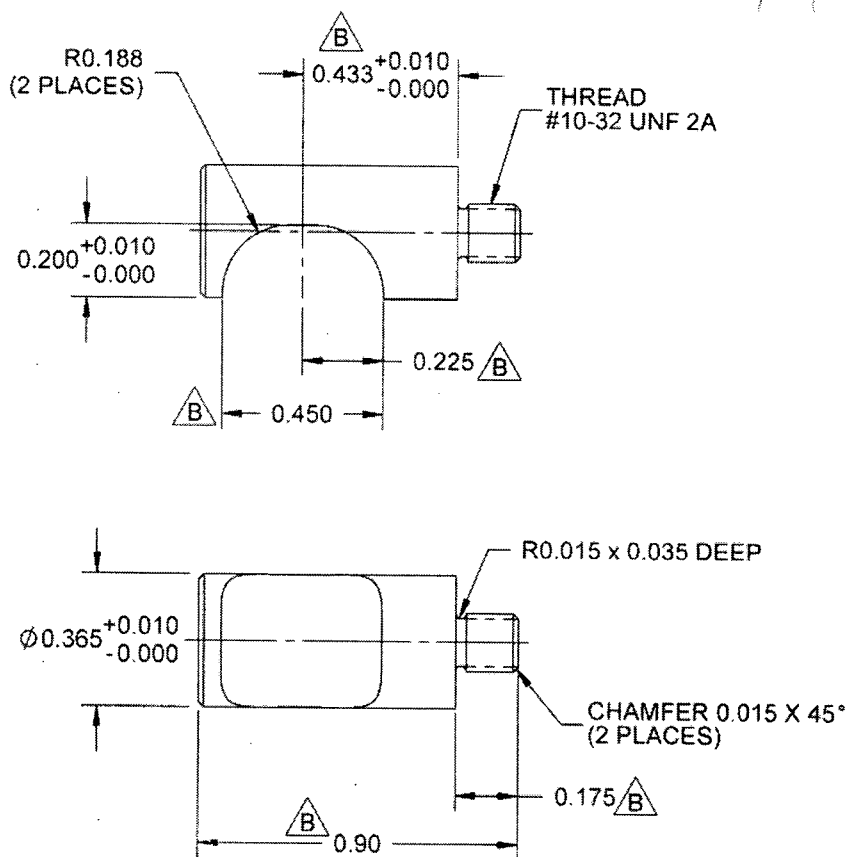
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.05.26	New Issue	KJ/JLM	



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 6 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

RELEASED
[Signature]
05/04/28



D3372-5 CAM LOCK SHAFT

76485

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.